

Work Order ID 85507

June-08-12 2:45:45 PM

85507

Page 1

Item ID: D206-651-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: 206A/B GHW

Stop ***NS2***

Start Date: 08/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/08

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2711/D2690

Rev A/B2

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-651-041 CHG001

5/2/08/06

OK for ch 12/7/0.

110

0.00

110

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut two cable CBL-1240 per assembly (10.75" each) Remove 2.25" of sleeve from each end of cable CBL-1240-Crimp CBL-460 onto CBL-1240 to make (2) D2690-8 as per Dwg D2690. (Leave one end open)3-Install Lanyard D2690-8 (from open end) into pin D2711 a

4x

12/07/05

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

5/2/07/05

(4)

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-651-041 CHG001 Location: <u>125</u> PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/7/10

CK 12/7/10

MF 12-07-09

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>																
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Offset/Setup									
Other									
Process									
Supplier									
Training									
Unauthorized									

FAULT CATEGORY

Landing Gear	Hardware	General	Maintenance
<input type="checkbox"/> Bending Passes Below Min	<input type="checkbox"/> Breaking	<input type="checkbox"/> Burrs	<input type="checkbox"/> Set-up
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> Missing	<input type="checkbox"/> Contamination	<input type="checkbox"/> Supplier
<input type="checkbox"/> Cracks	<input type="checkbox"/> Size/Length	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Crushed/Crimp at Bending	<input type="checkbox"/> Spinning	<input type="checkbox"/> Documentation/Data	<input type="checkbox"/> Weld
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Threading	<input type="checkbox"/> Finish	<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Other	<input type="checkbox"/> Wrong	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Positioned Wrong		<input type="checkbox"/> Inspection Unqualified	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Ripples on Inner Bend		<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Torque Waves in Extrusion		<input type="checkbox"/> Jigs/Fixtures/Tooling	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Turning Sequence		<input type="checkbox"/> Kit Incorrect	<input type="checkbox"/> Part Lost
<input type="checkbox"/> Wave/Twist in Tube		<input type="checkbox"/> Kit Missing	<input type="checkbox"/> Part Moved
			<input type="checkbox"/> Raw Material
			<input type="checkbox"/> Other

Picklist Print

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Page 1

Work Order ID: 85507

85507

Parent Item: D206-651-041

D206-651-041

Parent Item Name: 206A/B GHW

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev: F 02.08.14 Re-format KJ

IPP Rev: G Removed Purchasing 07-03-21 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN960JD10

NAS1149D0363J

Purchased

No

AN960JD10

Washer

CBL-1240

Purchased

No

CBL-1240

Cable

Location

Loc Qty

Loc Code

GA

385.681659

113565

3.911789

119021

368.73647

119690

13.0334

CBL-460

Purchased

No

CBL-460

Loop Sleeve

Location

Loc Qty

Loc Code

GA

786

121574

786

D2692

Manufactured

No

D2692

Spring Pin Clip

Location

Loc Qty

Loc Code

ST016

169

74121

169

**

**

**

**

16

7.52

16

4

4

9/5/12/07/05

9/5/12/07/05

9/5/12/07/05

9/5/12/07/05

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

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Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Material									
Offset/Setup									
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Process									
Supplier									
Training									
Unauthorized									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	Hardware <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong Drill Holes <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many	General <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing	<input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material <input type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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Parent Item: D206-651-041

Parent Item Name: 206A/B GHW

85507

D206-651-041

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 4.00

Required Qty: 4.00

D2711

Manufactured No

Each

130.0000

D2711

Lock Pin

**

4

Location

Loc Qty

Loc Code

ST016

47

79559

47

ST029

83

76581

83

MS21042L3

Purchased

No

Each

2,027.000

MS21042L3

Nut

**

4

Location

Loc Qty

Loc Code

ST300

2027

115835

4

117885

32

119017

900

119075

138

121349

143

121444

810

MS27039-1-08

Purchased

No

Each

1,437.000

MS27039-1-08

Screw

**

8

Location

Loc Qty

Loc Code

ST291

1437

117423

81

119075

1

120308

312

121011

43

121243

500

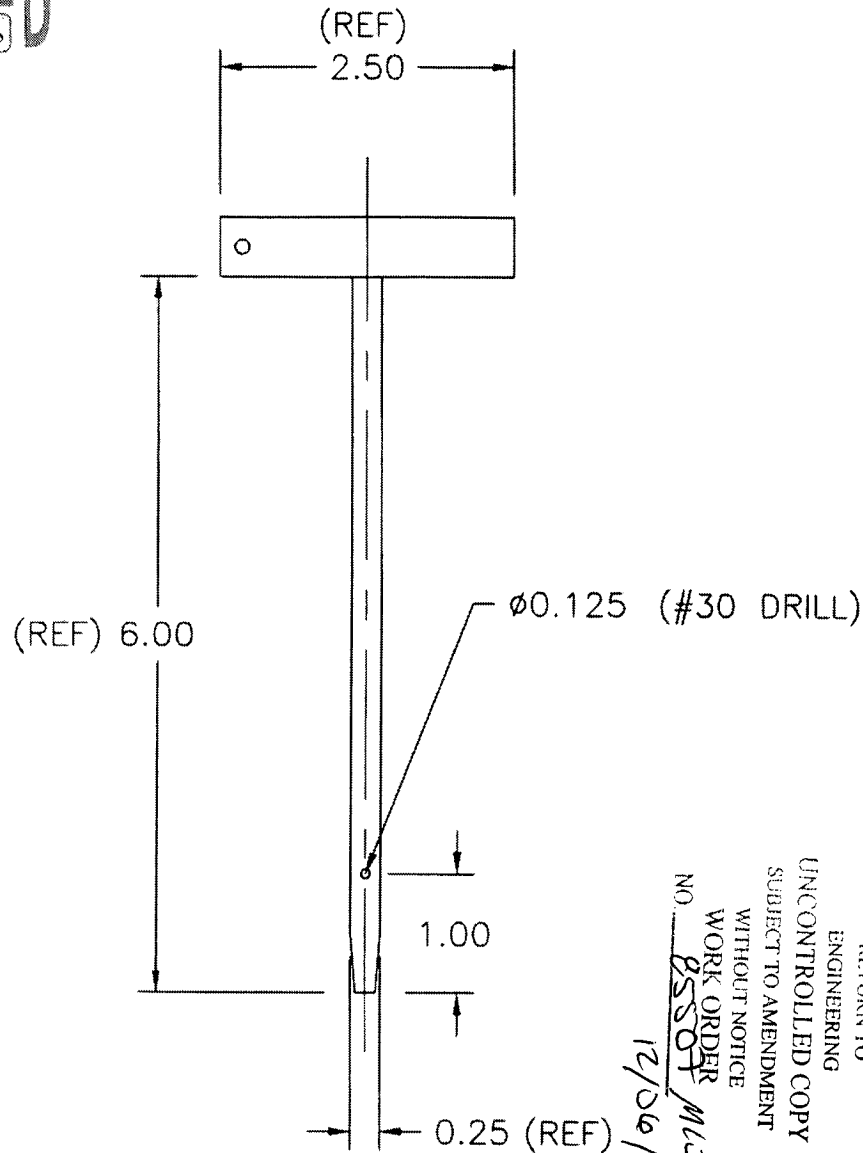
121708

500



DESIGN <i>may</i>	DRAWN BY <i>may</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>AS</i>	APPROVED <i>AS</i>	DRAWING NO. D2711	REV. A SHEET 1 OF 1
DATE 97.11.03		TITLE LOCK PIN	SCALE NTS
A	97.11.03	NEW ISSUE	

RELEASED
97/11/06 DS

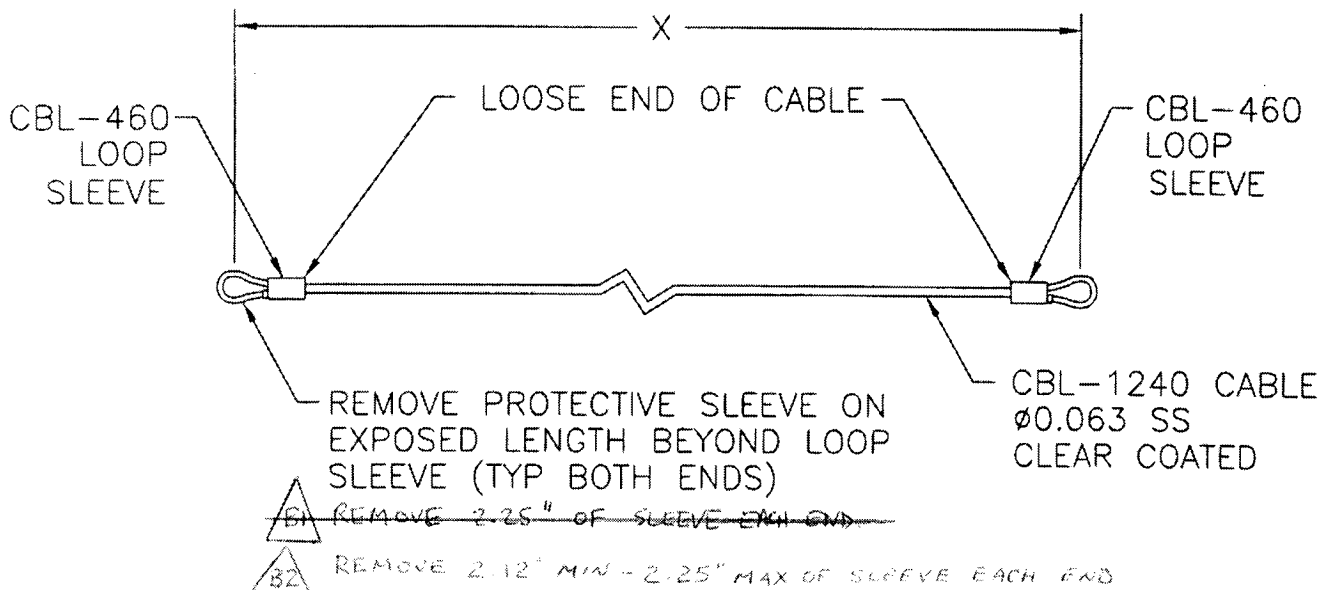


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85507 MLC
12/06/08



DESIGN <i>MEY</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>MEY</i>	APPROVED <i>BW</i>	DRAWING NO. D2690	REV. B SHEET 1 OF 1
DATE 97.10.02		TITLE LANYARD ASSEMBLY	SCALE NTS
A	97.07.03	NEW ISSUE	
B	97.10.02	REVISED NOTE FOR ADDITIONAL LENGTH	
B1	# CP 01.08.20	ADD NOTE TO REMOVE 2.25" OF SLEEVE	
B2	# 04.06.24	ADDED TOLERANCE	

RELEASED
971003 KE
TSR A374



D2690-X

X = LENGTH IN INCHES

NOTE: CUT CABLE 2.50* INCHES LONGER THAN 'X' LENGTH. FOLD ENDS TIGHT TO 'X' LENGTH AND CRIMP WITH SLEEVE AT END OF LOOSE END OF CABLE WITH CBL-705 CRIMPING TOOL.
*ADDITIONAL LENGTH MAY BE NECESSARY IN SOME APPLICATIONS. CUT AS REQUIRED.

NOTE: IN SOME CASES, END HAS TO BE CRIMPED AFTER ASSEMBLY WITH ATTACHING PARTS.

ASST

DEO's										
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